

Date: Thursday, 19/04/2007 12:57:17 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TOW RING
 Job Number : 31957
 Estimate Number : 10396
 P.O. Number : *N/A* Part Number : D2968041
 This Issue : 19/04/2007 S.O. No. : *N/A* Drawing Number : D2968
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : B1
 Previous Run : 31956 Material : *N/A*
 Written By : _____ Due Date : 26/04/2007 Qty: 40 Um: Each
 Checked & Approved By : _____
 Comment/ : Est:C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 31957A STEM



Comment: Sub-Component STEM
 D2968-1 B *29964*

FC 07/04/26 (40)

2.0 31957B RING



Comment: Sub-Component RING
 D2968-5 B *302748*

FC 07/04/20 (40)

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 Weld D2968-1 & D2968-5 as per Dwg D2968 & QSI 004 using 4130 welding rod Identify as D2968-041
 Batch: *M 19317*

FC 07/04/23 (40)

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/23 (40)

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/23 (48)

6.0 OUTSIDE SERV.30 OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING
 Issue P/O: *3611*
 Description: D2968-041 to heat treat to ultimate tensile strength
 125ksi as per Dwg D2968

C207/04/24 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/04/2007 12:57:17 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 31957

Part Number: D2968041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Conformity sheet required

Issue P/O: 3613

C 207/04/24 (40)

Cad Plate per QQ-P-416F Class I Type II

Conformity sheet required

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

07/07/16 (40)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT CAD PLATE

waited for heat treat cert
07-05-16

07-05-23 (40)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DO NOT POWDER COAT THREADS

M 104 144

07-06-04

(40x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M. A

07/06/04

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/06/04 (40)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/05

Job Completion



C 207/06/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Technical drawing of a mechanical part showing two views: a side view and a cross-sectional view.

Side View:

- Overall length: A
- Shoulder width: B (Tolerance: 0.000 to -0.010)
- Flange thickness: 0.150
- Center drill at the left end.
- Radius at the right end: $R1.500$

Cross-sectional View:

- Overall length: C
- Shoulder width: 0.063 (REF)
- Flange thickness: 0.500 (REF)
- Central hole diameter: 0.125 (Tolerance: $+0.010$ to 0.000)
- Radius at the left end: $R0.020$
- Radius at the shoulder: $R0.100$
- Surface finish symbols: $\triangle 4$, $\triangle B$, $\triangle 1$, $\triangle 2$, $\triangle 3$

Annotations:

- USE CENTER DRILL # 2
- 0.125 DEEP

MANCO**DOMPLEX**

8895 Crescent 3

Anjou (Québec) H1J 1B6

Tél.: 514-355-7867

Fax: 514-355-8750

CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

#

13272

Client / Customer Dart Aerospace LtdVotre # de commande / Your purchase order # 103613# de la pièce / part # D2968-041-B31957Notre # de bon de livraison / Our packing slip # 103911

Inspecteur / Inspector <u>Renault</u>	Date, équipe / Date, shift <u>14 MAY 2007</u>
Placage / Plating <u>QQP-P-416 F Class 1 Type II</u>	
Quantité totale / Total quantity <u>40</u>	Quantité inspectée / Inspected quantity <u>40</u>
Adhésion / Adhesion <u>Bonne</u>	
Épaisseur / Thickness L.C.D. H.C.D. Moy. / aver. <u>0.0005</u>	
Coulisses, taches / Leach, spots <u>non</u>	Rugosité / Roughness <u>non</u>
Quantité approuvée / Approved quantity <u>40</u>	Quantité rejetée / Rejected quantity <u>—</u>

Commentaires / Comments

Nous certifions que les pièces énumérées ci-dessus ont été faites en conformité avec vos dessins et spécifications et rencontrent les exigences contenues dans ces dessins et/ou spécifications.

We hereby certify that the parts listed above have been made in accordance with your drawings and specifications and are correct to the requirements contained in those drawings and/or specifications.

Signé au nom de
Signed on behalf of**MANCO**
DOMPLEX

RELEASE NOTE



VAC AERO
INTERNATIONAL INC.

GST No.: R105468102

OAK 86749-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION
7450 RUE VERTE STREET, ST. LAURENT, QUEBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

05/03/2007

MM/DD/YYYY

PAGE: 1

BILL TO:

1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: MANCO COMPLEX
4660 HICKMORE
ST. LAURENT, QC

K6A 1K7

H4T 1K2

DATE SHIPPED	SHIP VIA	F.O.B.
05/03/2007		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
3631		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHIPD	TEST RESULTS
D2968-041	TOW RING	EA	40	40	
Process Specifications: Procedure: 4047 HEAT TREATED TO 125 KSI MIN. 100% HARDNESS TESTED PER ASTM E-18, HRC 27-32.5 MATERIAL: 4130					
<div style="border: 1px solid black; padding: 5px; display: inline-block;"> 100% HARDNESS TESTED 40 p.p.s. 27/28 HRC </div>					
<div style="border: 1px solid black; border-radius: 50%; width: 40px; height: 40px; display: flex; align-items: center; justify-content: center; margin: 10px auto;"> VALQ TH. 25 Q.C. </div>					

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Diana Freeman
Authorized Q.C. Inspector



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT
THERMAL COMPONENT OVERHAUL - PLASMA AND OTHER COATINGS

HEAT
TREATING